




**DART**

DESIGN DS	DRAWN BY RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D3140	REV. D SHEET 1 OF 7
DATE 05.11.23		TITLE DOOR	SCALE NTS
A	02.04.18	NEW ISSUE	
B	03.01.23	REMOVE -65/-81/-83; ADD -301/-303	
C	04.11.08	CHANGE DELASTEK SPEC. TEC-77; ADD PART MARKING; ADD NOTES 11, 12, 13; CHANGE ANGLE -95/-97/-98 TO 106°	
D	05.11.23	ADD -103/-104/-105/-106; REMOVE -67	
DI	<del>06.03.31</del>	1.75 WAS 1.88; 4.75 WAS 4.13	

**UNDER REVIEW**

06.06.09 CB

RELEASED

05.12.01 



QTY -05	QTY -06	QTY -07	QTY -08	QTY -09	QTY -10	PART NUMBER	DESCRIPTION
X						D3140-05	DOOR
	X					D3140-06	DOOR
		X				D3140-07	DOOR
			X			D3140-08	DOOR
		1		X		D3140-09	DOUBLER ASSEMBLY
			1		X	D3140-10	DOUBLER ASSEMBLY
3	3					D3140-57	PAD
1	1					D3140-59	PAD
2	2					D3140-61	PAD
2	2					D3140-63	PAD
		1	1			D3140-69	PAD
		1	1			D3140-71	PAD
		1	1			D3140-73	PAD
		1	1			D3140-75	PAD
		1	1			D3140-77	PAD
		1	1			D3140-79	PAD
				1	1	D3140-85	ANGLE
1	1					D3140-87	DOUBLER
				1	1	D3140-89	DOUBLER
		1				D3140-91	DOUBLER
			1			D3140-92	DOUBLER
3	3					D3140-95	DOUBLER
1						D3140-97	DOUBLER
	1					D3140-98	DOUBLER
		1	1			D3140-99	DOUBLER
		2	2			D3140-101	DOUBLER
		1				D3140-103	DOUBLER
			1			D3140-104	DOUBLER
		1				D3140-105	DOUBLER
			1			D3140-106	DOUBLER
1	1					D3140-241	DOUBLER
1		1				D3140-301	DOUBLER
	1		1			D3140-303	DOUBLER
				5	5	MS20426AD3-4	RIVET



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CHECKED 	APPROVED 	DRAWING NO. D3140	REV. D SHEET 2 OF 7
DATE 05.11.23	TITLE DOOR		SCALE NTS

1

COMPOSITE LAYUP & BONDING I.A.W. DELASTEK PROCESS SPEC. TEC-77  
MATERIAL STORAGE & HANDLING TO BE I.A.W. DART QSI 006  
MAIN LAYUP USES FIBERCOTE E-761/7781 EPOXY FIBERGLASS.  
FILL WITH EPOCAST 87269 OR MAGNOBOND 77 A & B AND MA560 FOAM/ NB-51/30 FOAM


2

FINISH: DUPONT HIGHBUILD GREY PRIMER 1144-S

3

MAKE PARTS IN ACCORDANCE WITH THE FOLLOWING TOOLS/MOLDS:

PART	TOOL
D3140-05	B30-23000-01T
D3140-06	B30-23000-02T
D3140-07	B30-23000-03T
D3140-08	B30-23000-04T
D3140-57	B30-23000-57T
D3140-61	B30-23000-61T
D3140-63	B30-23000-63T
D3140-69	B30-23000-69T
D3140-71	B30-23000-71T
D3140-73	B30-23000-73T
D3140-75	B30-23000-75T
D3140-77	B30-23000-77T
D3140-79	B30-23000-79T
D3140-89	D3140-89T1
D3140-301	D3140-301T1
D3140-303	D3140-303T1

RELEASED  
05.12.01 

UNDER REVIEW

06.06.09 CB

4

MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK (M2024T3S.032)  
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

5

MATERIAL: 2024-T3 (QQ-A-250/4) 0.020 THICK (M2024T3S.020)  
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

6

MATERIAL: 5052-H32/H34 (QQ-A-250/8) 0.040 THICK (M5052H32S.040)  
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

7

MATERIAL: POLIMEX TR75 1" THICK 4.5 LB KLEGECELL

8

ALL DIMENSIONS IN INCHES

9

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

10

MATERIAL: 6061-T6 (QQ-A-250/11) 0.063 THICK (M6061-T6S.063)  
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

11

DOUBLER TO SIT ON TOP OF FOAM AT THIS LOCATION

12

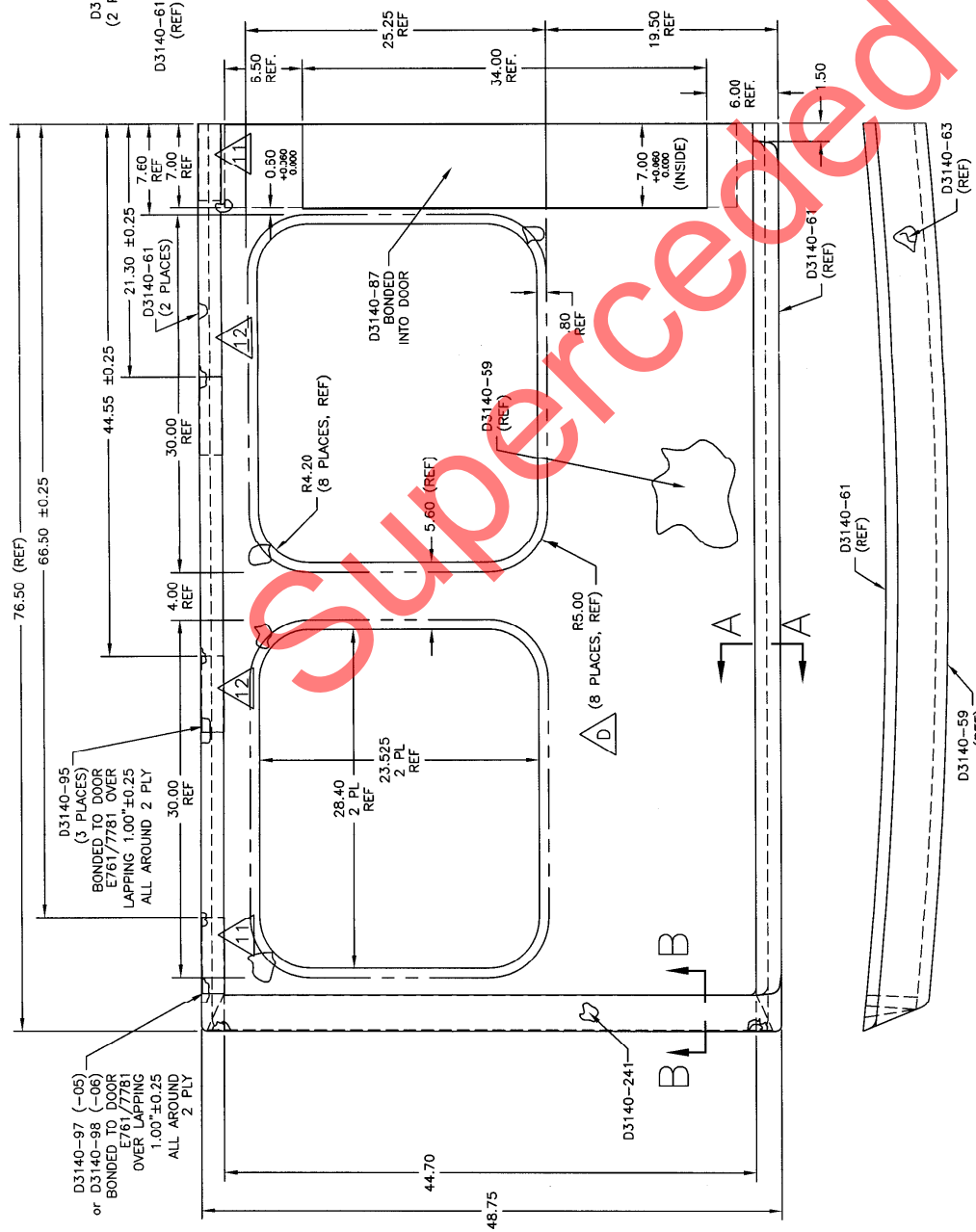
DOUBLER TO BE RECESSED FLUSH INTO FOAM AT THIS LOCATION

13

RUBBER STAMP WITH DART P/N D3140-05/-06/-07/-08 USING MIL-STD-130

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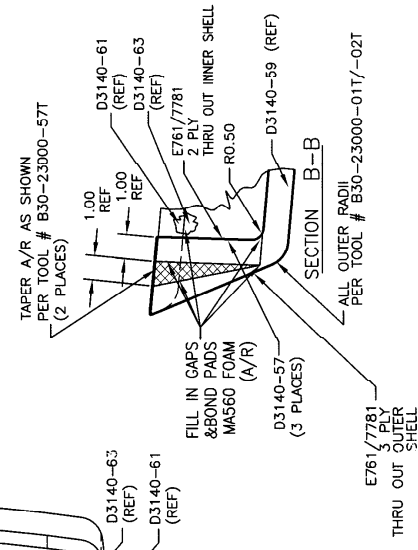
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## UNDER REVIEW

06.06.07 c2

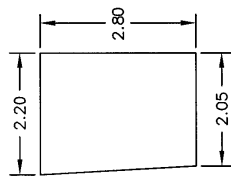
RELEASED  
05.20.50




D3140-05 DOOR (SHOWN, REPLACES PREMIER P/N B30-23000-05)  
D3140-06 DOOR (OPPOSITE, REPLACES PREMIER P/N B30-23000-06)  
 (WINDOWS & CUTOUTS TO BE LOCATED PER B30-23000-01T/-02T TOOL)

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		DATE 05.11.23	TITLE DOOR		SCALE NTS





**D3140-101 DOUBLER**   
(REPLACES PREMIER P/N B30-23000-101)

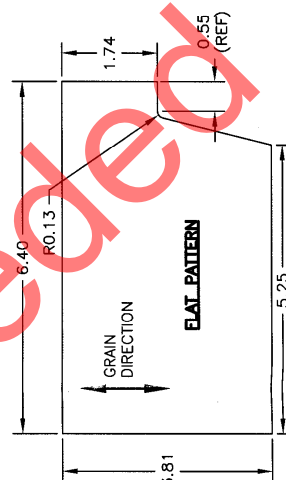


**D3140-91 DOUBLER**  
(SHOWN, REPLACES PREMIER P/N B30-23000-91)

**D3140-92 DOUBLER**  
(OPPOSITE, REPLACES PREMIER P/N B30-23000-92)

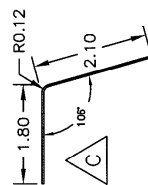
06.06.90.90

RELEASED  
# 102150



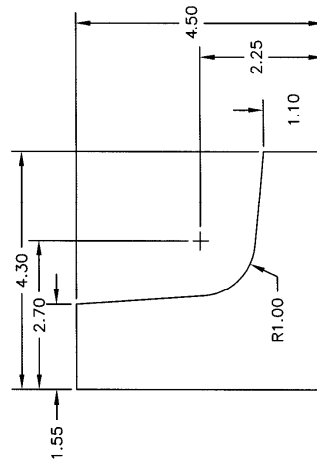
**D3140-97F FLAT PATTERN**  
(USE TO MAKE D3140-97/-98 DOUBLERS)

## BEND DETAIL




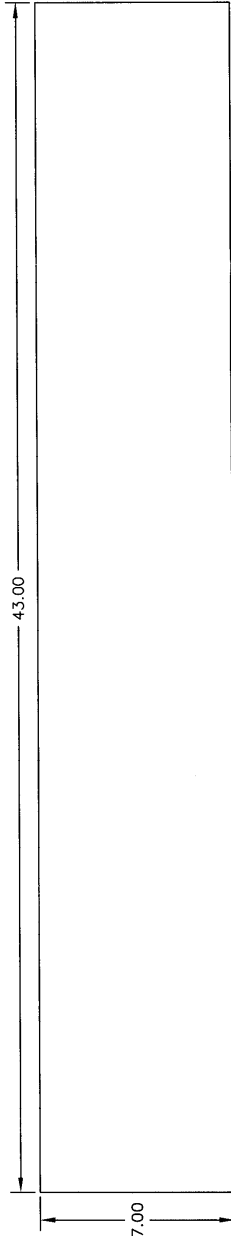
**D3140-97 DOUBLER**  
(SHOWN, REPLACES PREMIER P/N B30-23000-97)

**D3140-98 DOUBLER**  
(OPPOSITE, REPLACES PREMIER P/N B30-23000-98)

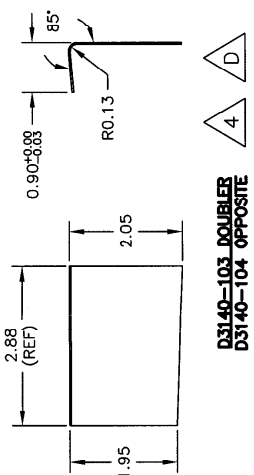


**D3140-99 DOUBLER**  
(REPLACES PREMIER P/N B30-23000-99)

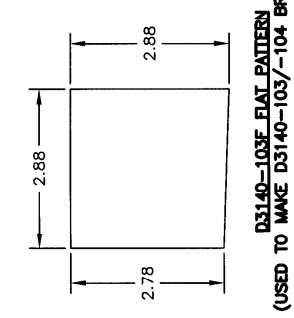
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DATE 05.11.23		TITLE DOOR			



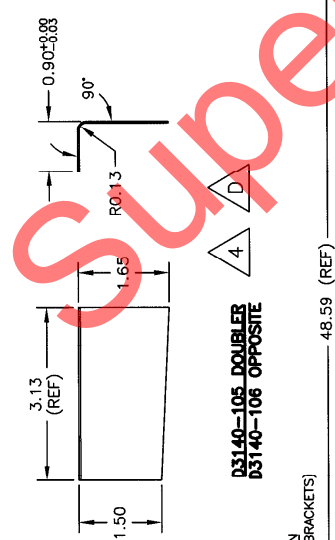
**D3140-87 DOUBLER**   
(REPLACES PREMIER P/N B30-23000-87)



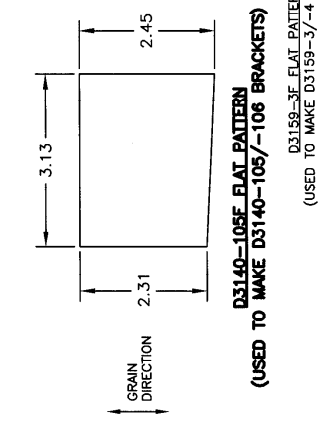
**D3140-103 DOUBLER**  
**D3140-104 OPPOSITE**



**D3140-103F FLAT PATTERN**  
(USED TO MAKE D3140-103/-104 BRACKETS)

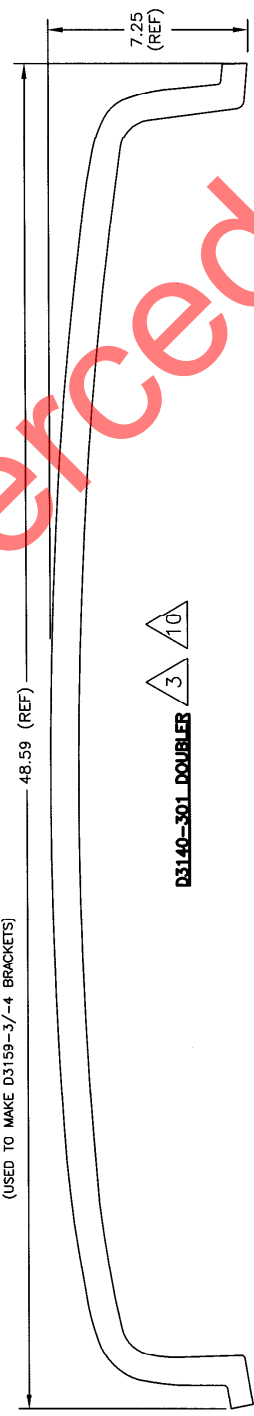


**D3140-105 DOUBLER**  
**D3140-106 OPPOSITE**

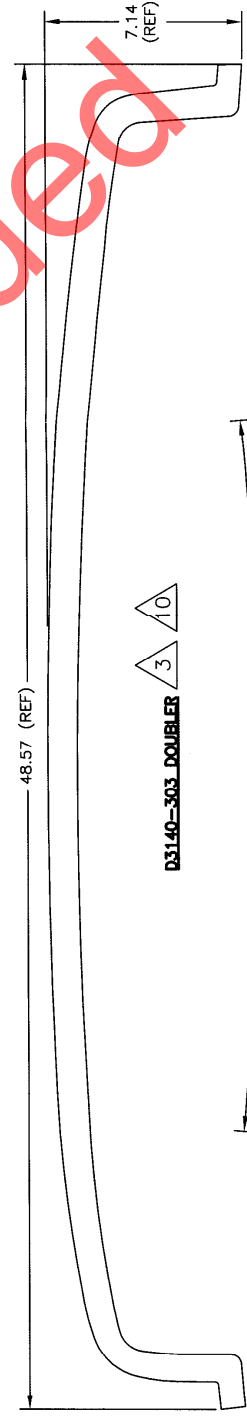


**D3140-105F FLAT PATTERN**  
(USED TO MAKE D3140-105/-106 BRACKETS)

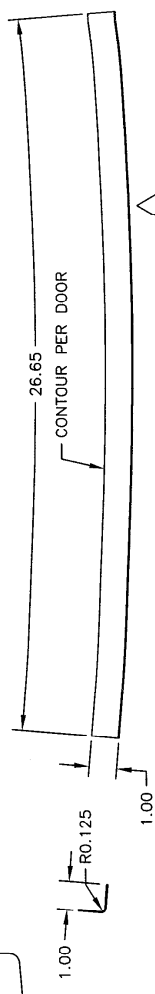
**D3159-3F FLAT PATTERN**  
(USED TO MAKE D3159-3/-4 BRACKETS)




**D3140-301 DOUBLER**  



**D3140-303 DOUBLER**  

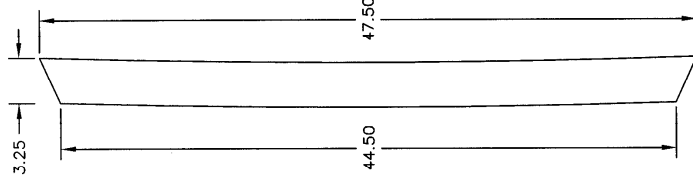
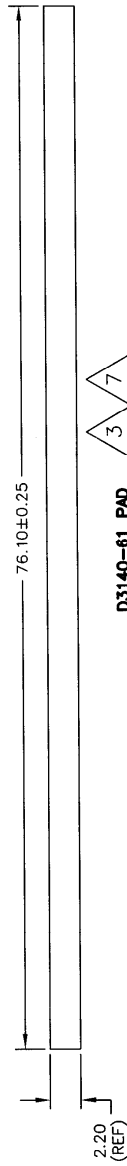


**D3140-85 ANGLE**   
FLAT PATTERN: 26.65" x 1.90"  
(REPLACES PREMIER P/N B30-23000-85)

RELEASED  
05.12.01

UNDER REVIEW  
06.06.09 C8

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DESIGN DS	DRAWN BY RF	CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3140	SHEET 6 OF 7	
DATE 05.11.23	TITLE DOOR		SCALE NTS			



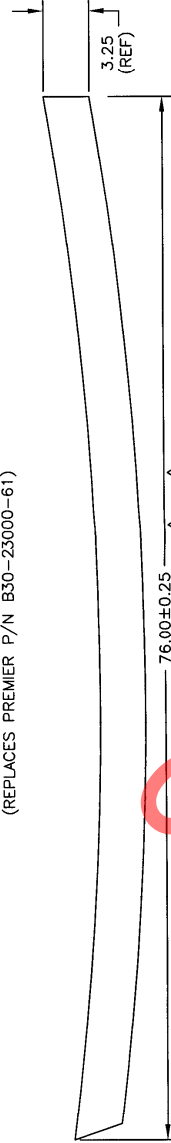
**D3140-241 DOUBLER**  
(REPLACES PREMIER P/N B30-23000-241)

5

**RELEASED**  
DS (12.01.10)

UNDER REVIEW

06.06.09 C.D.



R1.00  
(2 PLACES, REF)

**D3140-59 PAD**  
(REPLACES PREMIER P/N B30-23000-59)

7

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				DATE	05.11.23					DRAWING NO.	D3140
										TITLE	DOOR
										NTS	

REV. D  
SHEET 7 OF 7  
SCALE